

Date: Tuesday, 15/07/2008 9:14:12 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BALL STUD
Job Number	: 40478		
Estimate Number	: 12841		
P.O. Number	:	Part Number	: D36221
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3622 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38113	Material	:
Written By	:	Due Date	: 30/07/2008
Checked & Approved By	: <u>JUL 08.15.08</u>	Qty:	<u>50</u> Um: Each
Comment	: Est Rev:A New Issue 07-04-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR
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(32)

Comment: Qty.: 0.1134 f(s)/Unit Total : 2.2680 f(s)  
 303 HEX BAR .500"  
 Batch: M107980

MMF 08/07/16

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(32)

(P2)

Comment: HARDINGE CNC LATHE SMALL  
 1-TURN AS PER FOLIO FA686 & DWG D3622 ,  
 FOLIO REV: AA  
 DWG REV: A

2-DEBURR AS REQUIRED

MMF 08/07/16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(32)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/07/16

4.0	QC8	SECOND CHECK
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(32)

Comment: SECOND CHECK

S08/7/17

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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(32)

Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: 114

8/7/17

x32

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3622-1 PAR #: N/A Fault Category: Prod/Machined parts NCR: Yes No DQA: D Date: 08/07/17  
D412-658-023 QA: N/C Closed: D Date: 08/07/17

NCR: <u>40478</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/17	#	Some parts <u>are</u> 0.545" <del>length</del> in length instead of .563" R.L	<u>[Signature]</u> 08.07.17	Parts are accurate this one time only	<u>[Signature]</u> 08.07.17	<u>[Signature]</u> 08/07/17	<u>[Signature]</u> 08.07.17	<u>[Signature]</u> 08/07/17

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:14:12 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL STUD

Job Number: 40478

Part Number: D36221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 08-07-18*

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

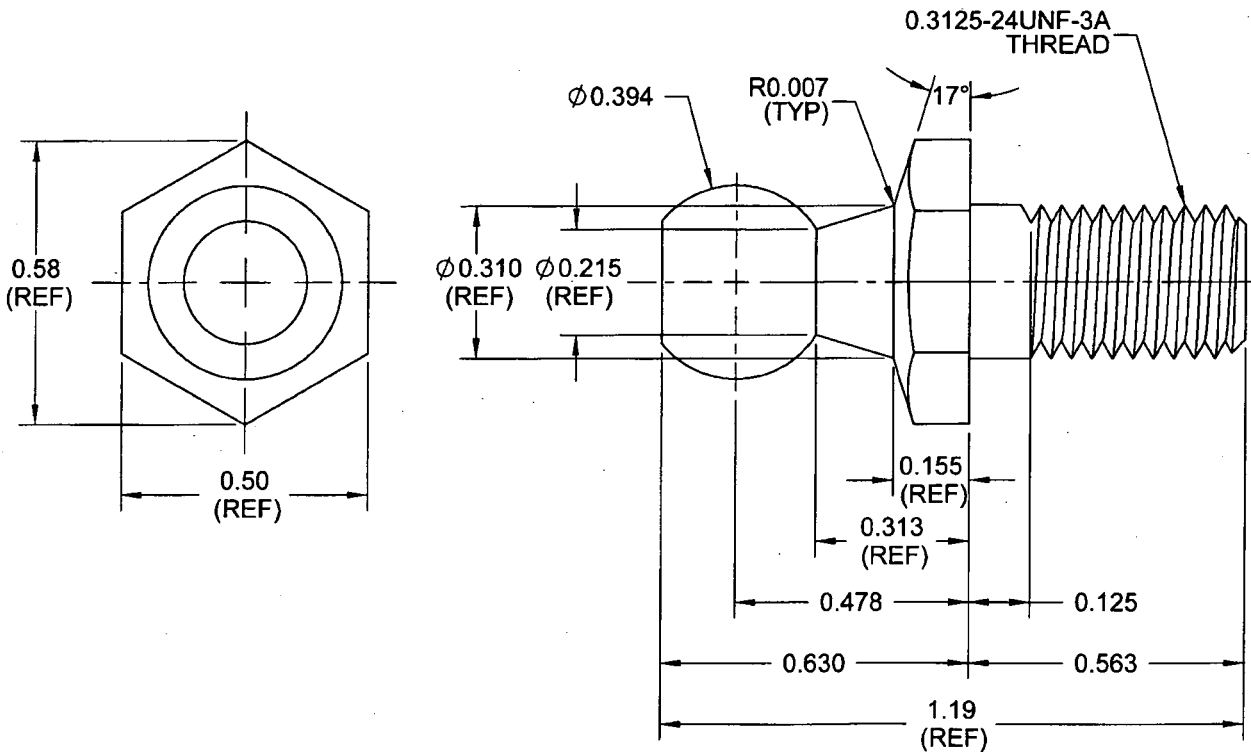
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART****RELEASED**  
07.07.11  
PER BCW# 1007

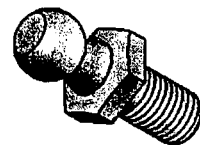
DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. <b>D3622</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.13</b>		TITLE <b>BALL STUD</b>	SCALE NTS
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3622-1 BALL STUD**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40478

**NOTES:**

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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